Guideline for initial sample deliveries including initial sample test report to Pankl Racing Systems AG – Drivetrain Systems

1. Revision

Version	Date	Change	Creator	Release
02	15.03.2021	Company name changed	Glatz	**15.03.2021**

2. Purpose

This guideline is intended to regulate the cooperation between Pankl Racing Systems AG - Drivetrain Systems (PDSYS) and the suppliers of purchase parts with regard to initial samples and their documentation in series production projects. Racing projects will be dealt with separately.

Sampling is the basis for the production process and product release. It proofs that the requirements agreed with the customer in drawings and specification are met. In coordination with PDSYS, samples and their scope have to be carried out according to VDA or AIAG or the corresponding documents have to be transmitted in conformity with VDA or AIAG.
Sampling is used in the following cases:

- New parts (if required by PDSYS)
- Changes to production (construction-, specification- material changes)
- Changes to production processes
- Relocations of production
- Prolonged interruption of production (12 months, spare parts are excluded)
- Re-qualification

3. Used items and abbreviations

PDSYS …….Pankl Racing Systems AG - Drivetrain Systems
Initial sample ....are products, that are fully compatible with standard operating equipment and standard conditions for production process and product release have been established.
EMT……..Initial sample parts
PPF ..... production process- and product release (sampling pursuant to VDA 2)
PPAP.....Production Part Approval Process (sampling pursuant to AIAG / QS 9000)
VDA …….Association of German Automobile Manufacturers
AIAG ..... Automotive Industry Action Group
DUNS .....Data Universal Numbering System
IMDS .....International Material Data System
MSA …….. Measurement system analysis

4. Submission stages

The submission stage describes which documentation has to be transmitted to the PDSYS. All the documents listed in the table must be available for internal release.

The scope of the sampling and the documents to be submitted are to be agreed with PDSYS or are specified on the order. Unless otherwise agreed, the PDSYS sample with associated documentation shall be submitted in accordance with PPF Submission Level 2 or PPAP Level 3.

4.1. Document checklist

In general, the document scope must be coordinated with the PDSYS. The following table gives an overview of the different submission levels according to VDA and AIAG.

V… Presentation to the customer/communicate before component delivery
D… Documentation remains with supplier, immediate presentation to customer on request
x… inapplicable

PPF (VDA)	PPAP (AIAG)	Scope as applicable to the product	Evidences	Submission levels								
				PPF				PPAP				
				0	1	2	3	1	2	3	4	5
-	18	Covering page / Part Submission Warrant	Basic data, signature in accordance with the authority matrix	V	V	V	V	V	V	V	V	Assessment on the production plant
1.1	9	Geometry, dimensional inspection	Measurement results for all characteristics on the customer drawing (Bubble Drawing)	D	D	V	V	D	V	V	Determined from the customer	
1.2	-	Functional check	If applicable f.e. check for freedom of movement, installation tests	D	D	V	V	x	x	x		
1.3	10	Material testing	Chemical, physical, metallurgical tests in accordance with the underlying material specifications including heat treatment and possibly tests out of the control plan	D	D	V	V	D	V	V		
2	14	Samples	Number or delivery quantity according to agreement	D	V	V	V	D	V	V		
3	1, 2	Technical specifications, Development documents	Customer drawing (Bubble Drawing), approved changes that are not recorded in the documents (specifications)	D	D	V	V	D	V	V		
4	4	Product-FMEA	Only in case of constructions/design responsibility	D	D	D	D	D	D	V		
5	3	Design release	Only in case of constructions/design responsibility, Design release from the customer	D	D	V	V	D	D	V		
6	(17)	Comply with legal requirements	If agreed, evidence of compliance with legal requirements (f.e. environment, safety, recycling)	x	V	V	V	D	D	V		
7	(18)	Material data sheet per IMDS	Registration of ingredients in IMDS (whole supply chain)	V	V	V	V	V	V	V		
8	-	Software test report	Confirmation of software tests	D	V	V	V	x	x	x		
9	6	Process-FMEA	Only available for inspection	D	D	D	D	D	D	V		
10	5	Process flow diagram	Production- and inspections steps with their sequence	D	D	D	V	D	D	V		
11	7	Control Plan	Including all product- and process characteristics and control measures	D	D	D	D	D	D	V		
12	11	Confirmation of process capability	Short-term ability of processes	D	D	V	V	D	D	V		
13	(17)	Achievement of special characteristics	Evidence for protection	x	x	V	V	D	D	D		
14	16	Test/inspection equipment list	If agreed, for product specific test equipment	D	D	D	V	D	D	D		
15	8	Capability study testing equipment	For the whole measuring and test equipment in the control plan	D	D	D	D	D	D	V		
16	-	Tooling list	Number of tools (origin/forming tools) or number of nests (injection molding), information about the tool concept	D	D	V	V	x	x	x		
17	-	Confirmation of agreed capacity	Process validation (Run @ Rate)	D	D	V	V	x	x	x		
18	-	Written self-assessment	Internal approval, operations which have no serial status	D	D	V	V	x	x	x		
19	2	Part history	Document including all changes concerning product and production process	D	V	V	V	D	V	V		
20	-	Confirmation of suitability of transport equipment	Evidence that storage and carriers don‘t impair parts	D	D	V	V	x	x	x		
21	-	PPF status of supply chain	Covering pages of sampling of purchased parts	D	D	V	V	x	x	x		
22	-	Approval of coating systems	If applicable approval of coating systems (e.g. paint adhesion)	D	D	V	V	x	x	x		
-	15	Master sample	A reference sample must be kept as long as the parts approval	x	x	x	x	D	D	D		
-	12	Documentation accredited laboratory	Accreditation oft he laboratory in case of external tests	x	x	x	x	D	V	V		
-	13	Appearance release report	Releases due to optical appearance of the parts	x	x	x	x	V	V	V		

5. Explanation of the documents

In the following the systems and the points to be filled in are described exemplarily. In the case of existing templates from the supplier, it must be ensured that the required information is included. PDSYS-specific can be requested from PDSYS Purchasing.

5.1. Cover page

Deckblatt

Absender	Empfänger		Vorlagestufe: 2
PANKL AUSTRIA SYSTEMS GMBH	PANKL Systems Austria GmbH DRIVETR	☑ Bericht Produktionsprozess- und Produktfreigabe	
Industriestrasse West 4	Industriestrasse West 4	☐ Bericht sonstige Muster	☐ Nachbemusterung
A - 8605 Kapfenberg	A - 8605 Kapfenberg	☑ (Neu-)Bemusterung	☐ Aussetzen der Fertigung länger als 12 Monate
		☑ Neuteil	☐ Änderungen in der Lieferkette
		☐ Änderungen am Produkt	
		☐ Änderungen am Produktionsprozess	

Anlagen / Einsichtnahme

Produkt/Prozess

☑ 1.1 Geometrie, Maßprüfung	☐ 1.9 ESD - Prüfung	☑ 8 Softwareprüfbericht	☑ 16 Werkzeugübersicht
☑ 1.2 Funktionsprüfung	☐ 1.10 Zuverlässigkeitsprüfungen	☐ 9 Prozess-FMEA	☑ 17 Nachweis vereinbarte Kapazität
☑ 1.3 Werkstoffprüfung	☑ 2 Muster	☐ 10 Prozessablaufdiagramm	☑ 18 Schriftliche Selbstbewertung
☐ 1.4 Haptikprüfung	☑ 3 Technische Spezifikation	☐ 11 Produktionslenkungsplan	☑ 19 Teilelebenslauf
☐ 1.5 Akustikprüfung	☐ 4 Produkt-FMEA	☑ 12 Prozessfähigkeitsnachweis	☑ 20 Eignungsnachweis Ladungsträger
☐ 1.6 Geruchsprüfung	☑ 5 Konstruktionsfreigabe	☑ 13 Absicherung besondere Merkmale	☑ 21 PPF Status Lieferkette
☐ 1.7 Aussehensprüfung	☑ 6 Einhaltung gesetzlicher Forderungen	☐ 14 Prüfmittelliste	☑ 22 Freigabe von Beschichtungssystemen
☐ 1.8 Oberflächenprüfung	☑ 7 Materialdatenblatt/IMDS	☐ 15 Prüfmittelfähigkeitsnachweis	☐ 23 Sonstiges

Lieferantenangaben

Lieferant / Produktionsstandort:	PANKL AUSTRIA SYSTEMS GM	Kennnummer / DUNS-Code:		Kunde:	PANKL SYSTEMS AUSTRIA GMBH
Benennung:	Beilage	Lieferscheinnummer:		Berichts-Nr.:	2016_00112
Sachnummer:	27896	Liefermenge:		Wareneingangs-Nr. / - datum:	
Zeichnungs-Nr.:	ZCHNG123456789cd	Chargennummer:		Bestellabruf-Nr. / -datum:	
Stand / Datum:	01 / 30.10.2017	Mustergewicht:		Abladestelle:	

Bestätigung Lieferant – Hiermit wird bestätigt, dass die Bemusterung entsprechend den vereinbarten Vorlagestufen, gemäß VDA Band 2 durchgeführt worden sind.

Name:	Glatz, Gerhard	Telefon:	+43 3862 33999 364
Abteilung:	QS	Fax/Email:	+43 3862 33999
			Gerhard.Glatz@pankl.com

☑ Der IMDS-Datensatz wurde erstellt unter der IMDS-ID-Nr: 123456789

Bemerkung: Datum: Unterschrift:

Entscheidung Kunde

	Freigaben			Produkt/Prozess																														
	Gesamt	Gesamt Prozess	Gesamt Produkt	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	1.9	1.10	2	3	4	5	5	7	3	3	10	11	12	13	14	15	16	17	18	19	20	21	22	23
i.O.	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
bedingt i.O. - Nachbemusterung erforderlich	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
n.i.O. – Nachbemusterung erforderlich	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐

Nr. Abweichgenehmigung:	Gültig bis:	Stückzahl:	Termin Nachbemusterung:	Bei Rücksendung: Lieferschein-Nr. / -datu

Name:	Glatz, Gerhard	Telefon:	+43 3862 33999 364	
Abteilung:	QS	Fax/Email:	+43 3862 33999	Gerhard.Glatz@pankl.com

Bemerkung: Datum: Unterschrift:

Verteiler:	1	2	3	4	5	6	7	8	9	10	11	12	13	14

1. Full address of the supplier

2. Full address PDSYS

3. Sample reason

4. Presentation stage (unless otherwise agreed PPF Level 2/ PPAP Level 3)

5. Appendix (by arrangement with PDSYS)

6. Product and supplier Data

7. Confirmation of the supplier, possible remarks, IMDS entry

5.2. Index

Inhalt des PPF-Berichtes

Lieferant / Produktionsstandort: PANKL AUSTRIA SYSTEMS	**Kunde:** PANKL SYSTEMS AUSTRIA GMBH [A,
Kennnummer / DUNS-Code:	Kennnummer:
Berichts-Nr.: 2016_XYZ Index: 01	Berichts-Nr.: 2016_00112 Index: 1 Vom Kunden auszufüllen
Benennung: Beilage Sachnummer: 27896	Zeichnungs-Nr.: ZCHNG123456789od Stand / Datum: 01 / 30.10.2017

Anlage	Stand / Datum	Art, Umfang und Kennzeichnung der Anlage
☑ 1.1 Geom[illegible], Maßprüfung	1 / 06.02.2017	Maßprotokoll
☑ 1.2 Fu[illegible]tionsprüfung	1 / 06.02.2017	Funktionsprüfung
☑ 1.3 Werkstoffprüfung	1 / 06.02.2017	Werkstoffprüfung
☐ 1.4 Haptikprüfung		
☐ 1.5 Akustikprüfung		
☐ 1.6 Geruchsprüfung		
☐ 1.7 Aussehensprüfung		
☐ 1.8 Oberflächenprüfung		
☐ 1.9 ESD - Prüfung		
☐ 1.10 Zuverlässigkeitsprüfungen		
☑ 2 Muster	1 / 06.02.2017	Musteranzahl
☑ 3 Technische Spezifikation	1 / 06.02.2017	gestempelte Zeichnung
☐ 4 Produkt-FMEA		
☑ 5 Konstruktionsfreigabe	1 / 06.02.2017	Ko-Freigabe
☑ 6 Einhaltung gesetzlicher Forderungen	1 / 06.02.2017	gesetzlichen Forderungen
☑ 7 Materialdatenblatt/IMDS	1 / 06.02.2017	Materialzertifikate / IMDS
☑ 8 Softwareprüfbericht	1 / 06.02.2017	Softwareprüfbericht
☐ 9 Prozess-FMEA		
☐ 10 Prozessablaufdiagramm		
☐ 11 Produktionslenkungsplan		
☑ 12 Prozessfähigkeitsnachweis	1 / 22.11.2016	spc
☑ 13 Absicherung besondere Merkmale	1 / 22.11.2016	Absicherung besonderer Merkmale
☐ 14 Prüfmittelliste		
☐ 15 Prüfmittelfähigkeitsnachweis		
☑ 16 Werkzeugübersicht	1 / 22.11.2016	Werkzeugübersicht
☑ 17 Nachweis vereinbarte Kapazität	1 / 22.11.2016	Prozessvalidierung
☑ 18 Schriftliche Selbstbewertung	1 / 22.11.2016	Selbstbewertung
☑ 19 Teilelebenslauf	1 / 24.11.2016	Teilelebenslauf
☑ 20 Eignungsnachweis Ladungsträger	1 / 22.11.2016	Verpackungsvorschriften
☑ 21 PPF Status Lieferkette	1 / 22.11.2016	PPF Lieferkette
☑ 22 Freigabe von Beschichtungssystemen	1 / 22.11.2016	Beschichtungsfreigabe
☐ 23 Sonstiges		

Bemerkungen Lieferant:

Name:	Glatz, Gerhard
Abteilung:	QS
Telefon:	+43 3862 33999 364
Fax:	+43 3862 33999
E-Mail:	Gerhard.Glatz@pankl.com
Datum:	Unterschrift:

1. Header Data

2. Mark attached documents

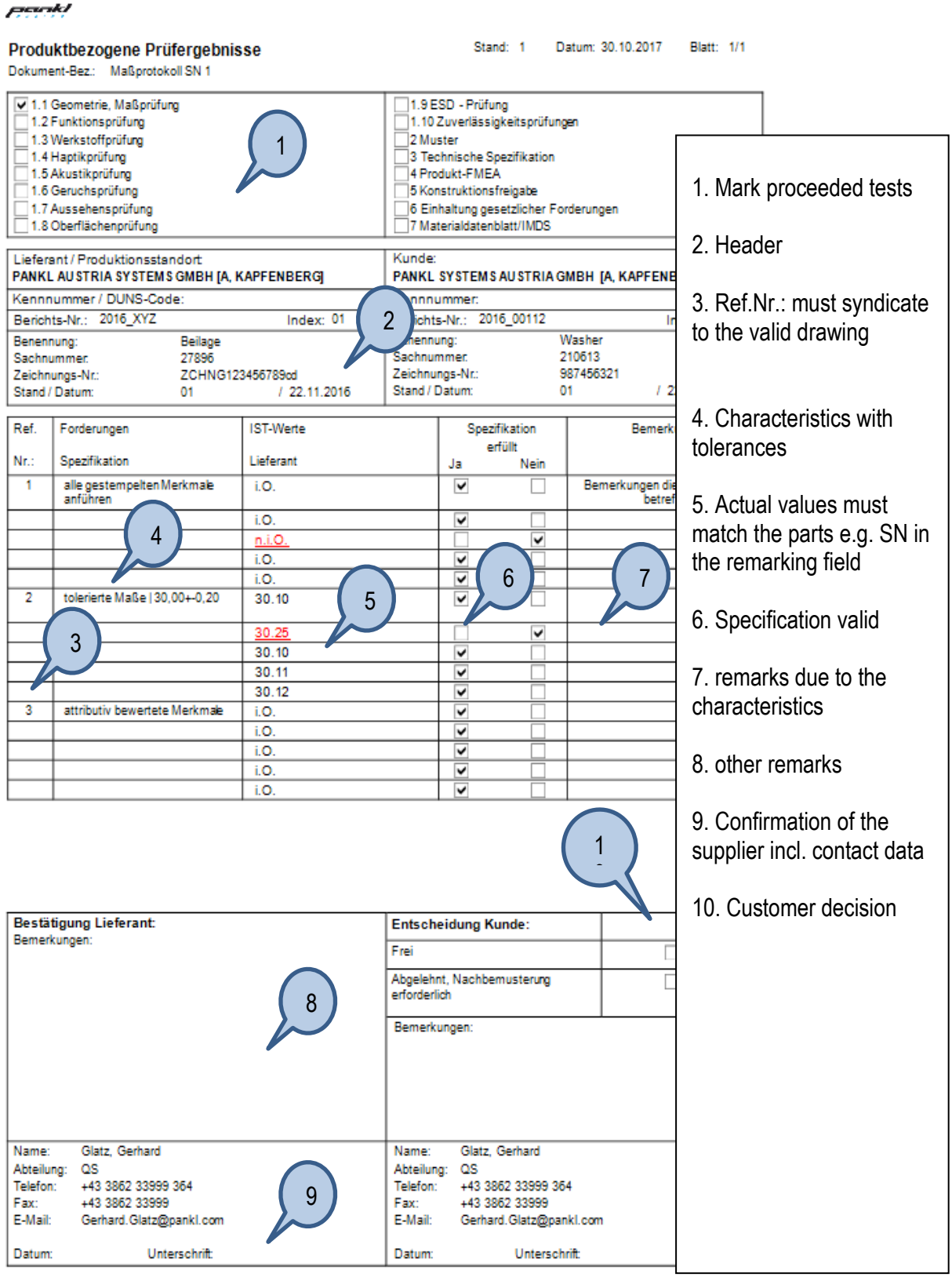
3. Revision and date of attached documents

4. e.g. Title, pages, missing documents etc.

5. possible remarks

6. confirmation from the supplier

5.3. Geometry, Dimensional inspection



Produktbezogene Prüfergebnisse Stand: 1 Datum: 30.10.2017 Blatt: 1/1

Dokument-Bez.: Maßprotokoll SN 1

☑ 1.1 Geometrie, Maßprüfung	☐ 1.9 ESD - Prüfung
☐ 1.2 Funktionsprüfung	☐ 1.10 Zuverlässigkeitsprüfungen
☐ 1.3 Werkstoffprüfung	☐ 2 Muster
☐ 1.4 Haptikprüfung	☐ 3 Technische Spezifikation
☐ 1.5 Akustikprüfung	☐ 4 Produkt-FMEA
☐ 1.6 Geruchsprüfung	☐ 5 Konstruktionsfreigabe
☐ 1.7 Aussehensprüfung	☐ 6 Einhaltung gesetzlicher Forderungen
☐ 1.8 Oberflächenprüfung	☐ 7 Materialdatenblatt/IMDS

Lieferant / Produktionsstandort:	Kunde:
PANKL AUSTRIA SYSTEMS GMBH [A, KAPFENBERG]	**PANKL SYSTEMS AUSTRIA GMBH [A, KAPFENE**
Kennnummer / DUNS-Code:	nnnummer:
Berichts-Nr.: 2016_XYZ Index: 01	chts-Nr.: 2016_00112 In
Benennung: Beilage	ennung: Washer
Sachnummer: 27896	Sachnummer: 210613
Zeichnungs-Nr.: ZCHNG123456789cd	Zeichnungs-Nr.: 987456321
Stand / Datum: 01 / 22.11.2016	Stand / Datum: 01 / 2

Ref. Nr.:	Forderungen Spezifikation	IST-Werte Lieferant	Spezifikation erfüllt Ja	Nein	Bemerk
1	alle gestempelten Merkmale anführen	i.O.	☑	☐	Bemerkungen die betref
		i.O.	☑	☐	
		n.i.O.	☐	☑	
		i.O.	☑	☐	
		i.O.	☑	☐	
2	tolerierte Maße | 30,00+-0,20	30.10	☑	☐	
		30.25	☐	☑	
		30.10	☑	☐	
		30.11	☑	☐	
		30.12	☑	☐	
3	attributiv bewertete Merkmale	i.O.	☑	☐	
		i.O.	☑	☐	
		i.O.	☑	☐	
		i.O.	☑	☐	
		i.O.	☑	☐	

Bestätigung Lieferant:	**Entscheidung Kunde:**
Bemerkungen:	Frei ☐
	Abgelehnt, Nachbemusterung erforderlich ☐
	Bemerkungen:
Name: Glatz, Gerhard Abteilung: QS Telefon: +43 3862 33999 364 Fax: +43 3862 33999 E-Mail: Gerhard.Glatz@pankl.com Datum: Unterschrift:	Name: Glatz, Gerhard Abteilung: QS Telefon: +43 3862 33999 364 Fax: +43 3862 33999 E-Mail: Gerhard.Glatz@pankl.com Datum: Unterschrift:

1. Mark proceeded tests

2. Header

3. Ref.Nr.: must syndicate to the valid drawing

4. Characteristics with tolerances

5. Actual values must match the parts e.g. SN in the remarking field

6. Specification valid

7. remarks due to the characteristics

8. other remarks

9. Confirmation of the supplier incl. contact data

10. Customer decision

5.4. Material testing

If the material is provided by the PDSYS, no separate protocols are required. For materials provided by the supplier, the minimum requirement is a 3.1 works certificate from the material manufacturer. Material tests where the base material is tempered must be coordinated with the R&D department of PDSYS as well as verified within protocols.

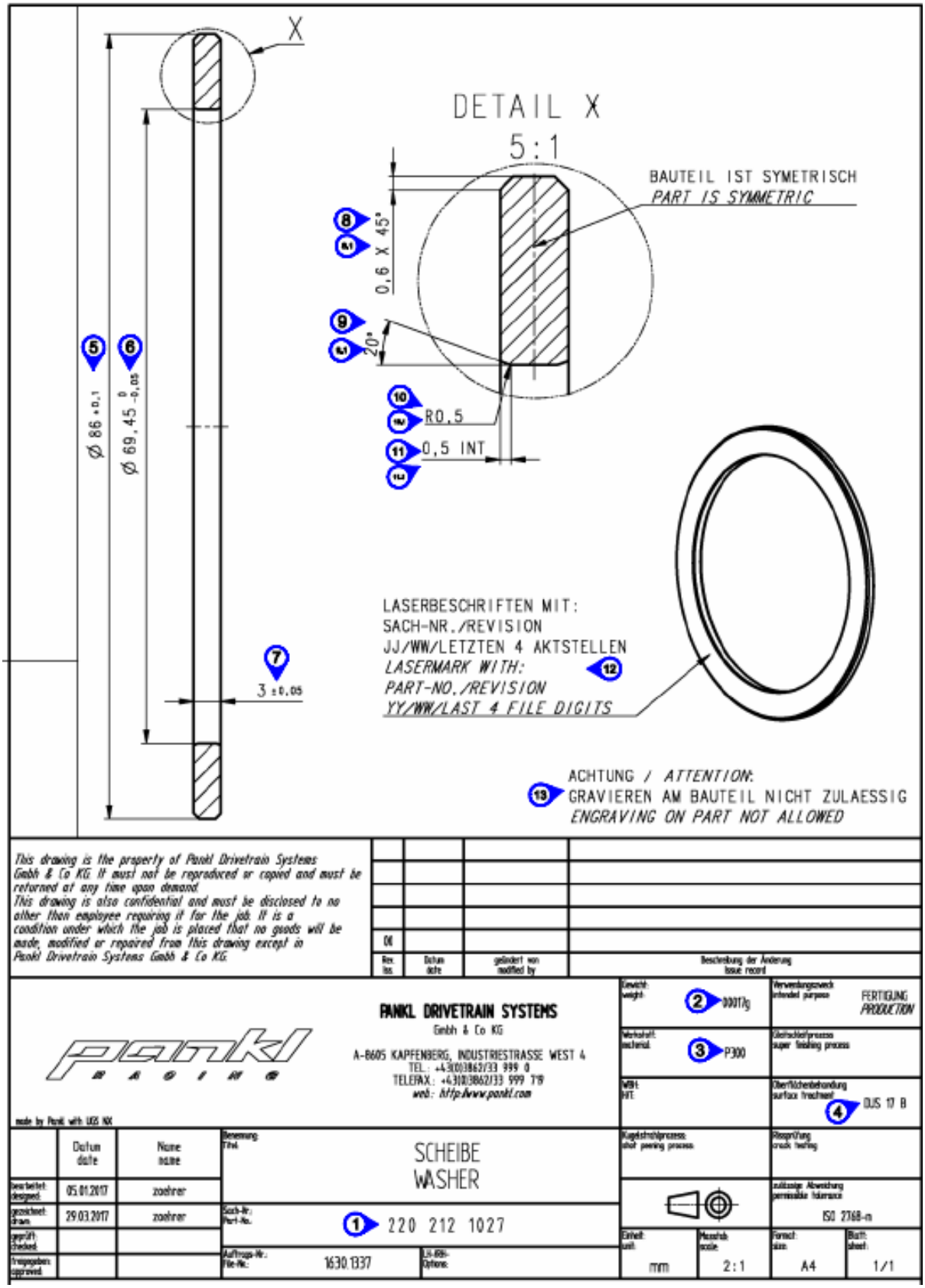
5.5. Samples

The number of samples has to be coordinated with the PDSYS. The minimum requirement is a 100% measurement and documentation of at least **one** component. For mirror-like components (LH/RH) separate samples are required. The numbered initial samples have to be marked as well as clearly assigned to the measurements.

5.6. Technical specifications, Development documents

For suppliers with design responsibility, a valid drawing must be provided. In the case of deviations from the specifications permitted by PDSYS, the suppliers' approval has to be claimed at the responsible purchaser of PDSYS and has to be attached to the delivery, including the cause of the defect and the planned avoidance of the defect.

A signed drawing is required to assign the product characteristics. The characteristics in the inspection reports must correspond to the drawing. It must be ensured that not only dimensional characteristics but also any notes or important instructions are stamped and checked (e.g. weight, lettering, references to standards,...). As long as the numbering is legible, it can also be handwritten.


X
DETAIL X
5 : 1
BAUTEIL IST SYMETRISCH
PART IS SYMMETRIC
8
8.1
0,6 X 45°
9
9.1
20°
10
10.1
R0,5
11
11.1
0,5 INT
5
Ø 86 +0,1
6
Ø 69,45 0 -0,05
7
3 ±0.05
LASERBESCHRIFTEN MIT:
SACH-NR./REVISION
JJ/WW/LETZTEN 4 AKTSTELLEN
LASERMARK WITH:
12
PART-NO./REVISION
YY/WW/LAST 4 FILE DIGITS
13
ACHTUNG / ATTENTION:
GRAVIEREN AM BAUTEIL NICHT ZULAESSIG
ENGRAVING ON PART NOT ALLOWED
This drawing is the property of Pankl Drivetrain Systems Gmbh & Co KG. It must not be reproduced or copied and must be returned at any time upon demand.
This drawing is also confidential and must be disclosed to no other than employee requiring it for the job. It is a condition under which the job is placed that no goods will be made, modified or repaired from this drawing except in Pankl Drivetrain Systems Gmbh & Co KG.
Rev. Iss.
Datum date
geändert von modified by
Beschreibung der Änderung issue record
PANKL DRIVETRAIN SYSTEMS
Gmbh & Co KG
A-8605 KAPFENBERG, INDUSTRIESTRASSE WEST 4
TEL.: +43(0)3862/33 999 0
TELEFAX: +43(0)3862/33 999 779
web: http://www.pankl.com
made by Pankl with UGS NX
Gewicht: weight
2 0.0017 kg
Verwendungszweck intended purpose
FERTIGUNG PRODUCTION
Werkstoff: material
3 P300
Gleitschleifprozess super finishing process
WBH: HT
Oberflächenbehandlung surface treatment
4 DLS 17 B
Kugelstrahlprozess shot peening process
Rissprüfung crack testing
zulässige Abweichung permissible tolerance
ISO 2768-m
Einheit: unit
mm
Maßstab: scale
2:1
Format: size
A4
Blatt: sheet
1/1
Datum date
Name name
bearbeitet: designed
05.01.2017
zoehrer
gezeichnet: drawn
29.03.2017
zoehrer
geprüft: checked
freigegeben: approved
Benennung: Titel
SCHEIBE
WASHER
Sach-Nr.: Part-No.
1 220 212 1027
Auftrags-Nr.: File-Nr.
1630.1337
UA-Nr.: Options:

5.7. Product FMEA

If the product is developed by the supplier, the implementation of a product FMEA must be verified by a cover sheet sampling. Upon request, D-FMEA shall be presented at the supplier's premises for inspection.

5.8. Design Release

As an order is usually only placed after design approval has been given, the submission of the design approval is not required.

5.9. Comply with legal requirements

If agreed and applicable, evidence of compliance with legal requirements must be enclosed.

5.10. Material data sheer per IMDS

In coordination with PDSYS. The released entry must be documented on the cover sheet (PSW). If this is not possible, early confirmation is required (Purchasing PDSYS).

5.11. Software test report

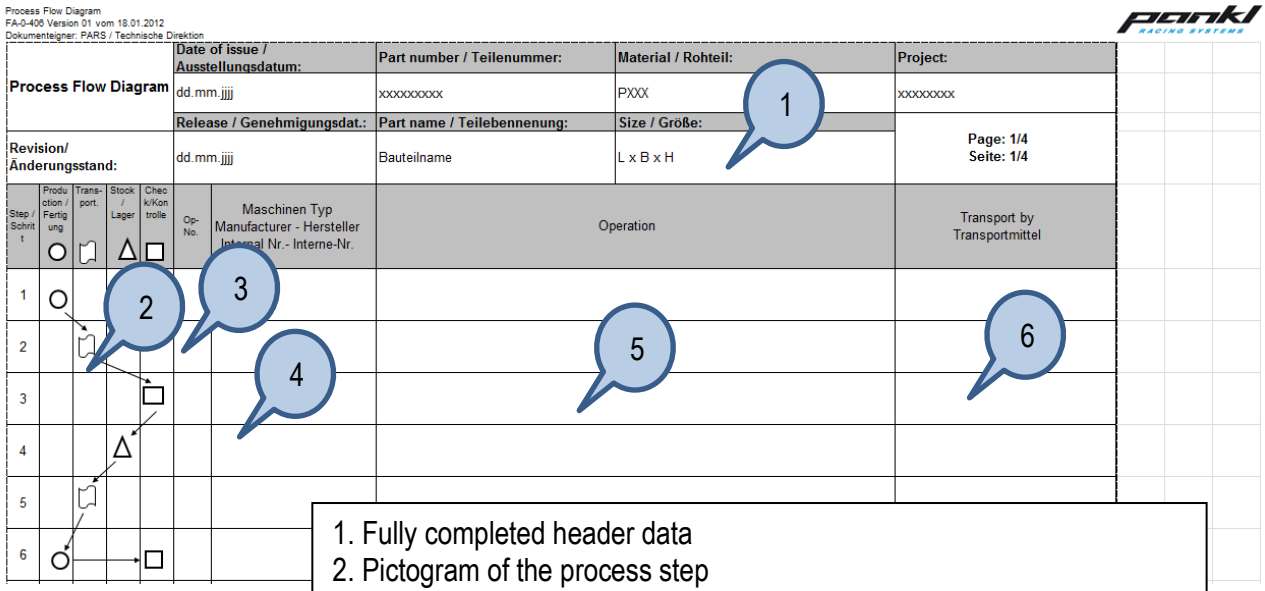
Not applicable for PDSYS products.

5.12. Process FMEA

The execution of a process - FMEA has to be proven by means of a cover sheet. Upon request P-FMEA shall be presented to the supplier for inspection on site.

5.13. Process Flow Chart

The description of the process flow and the associated test steps can be done by describing the work steps (see Pankl template) or by means of a flow chart.



1. Fully completed header data
2. Pictogram of the process step
3. Work step number - e.g. Afo 50
4. Machine -- e.g. MA100815 Mazak Variaxis
5. Description of the process step – e.g. eroding
6. Transport Description – for example: external transport to blasting process

5.14. Production Control Plan (PLP) / Control Plan

Product/process characteristics relating to the final product must be described with the associated tests, measurement equipment, frequency of tests and reaction plan. The process steps must correspond to the process flow diagram. Special features and 100% controls must be specially marked (column "K", special designation,...)

Control-Plan
FA-1-045 Version 01 vom 28.08.2014
Dokumenteigner: PDSYS / QS

Prototyp:	Vorserie:	Serie:	Kontaktperson/Telefon:	Datum:	Verändert:
Control-Plan Nummer:			Kernteam:	Datum/Freigabe durch Kundenentwicklung (falls erford.):	
Teilenummer/Änderungsstand:			Lieferant/Standort Freigabe/Datum:	Datum/Freigabe durch Kunden-Qualitätsbereich (falls erford.):	
Teilename/Beschreibung:			Datum/Weitere Freigabe (falls erford.):	Datum/Weitere Freigabe (falls erford.):	
Lieferant/Standort:	Lieferantenschlüssel:				

Nr.	Prozesselement	Maschine	Merkmale			K	Methoden					Reaktionsplan
			Nr.	Produkt-merkmal (Toleranz)	Prozess-merkmal (Toleranz)		Spezifikation / Toleranz	Prüfmittel	Stichproben		Lenkungs-methode	
									Umfang	Häufigkeit		

5.15. Confirmation of process capability

In coordination with PDSYS. See section 4.17 securing special features

5.16. Achievement of special characteristics

To ensure special characteristics, a 100% measurement incl. documentation or SPC (cpk≥1,66) has to be performed.

5.17. Test/Inspection equipment list

A list of the test equipment used has to be send to the PDSYS in accordance with the submission stage. The gauge types must correspond to the records in the PLP.

5.18. Capability study testing equipment

In general, the test equipment must be adapted to the tolerance of the characteristic. Measuring equipment which is used for special characteristics has to show an MSA/GRR according to the submission stage.

5.19. Tooling list

If several tools or nests are used, a separate initial sample must be created for each tool/nest. Traceability to the respective tools/nests must be ensured.
In the case of purely metal-cutting machining, the overview of the machines used in the process flow diagram is sufficient. Traceability to the respective machine used must be ensured.

5.20. Confirmation of agreed capacity

Proof of process validation must only be provided in consultation with PDSYS.

5.21. Written self assessment

Internal release for operations that do not yet have a serial status with regard to process and product characteristics. (e.g.: For the first sample delivery, the components are deburred manually, but a vibratory finishing process will be implemented in the serial production).

5.22. Part history

It is necessary to keep a record of all process and product changes on the basis of a part life cycle. In case of changes, it must be agreed with PDSYS whether a new sampling is necessary or whether a cover sheet sampling (cover sheet, part history, documents concerning changes, e.g.: measurement of a drawing detail) is sufficient.

Teilelebenslauf
part history

Kunde / customer: **Pankl Austria Systems GmbH**
Industriestraße West 4
A-8605 Kapfenberg

Lieferant / supplier:

Projekt / project:
Bauteilbezeichnung / part:

Zeichnungsnummer / drawing no.:
Pankl:
Kunde / customer: --

lfd. Nummer/ no.	Zeichnung-Rev./ drawing issue	Laufkarten-AE Stand/ process card issue	Datum/ date	Beschreibung/ description	geändert von/ changed from	Bemerkung/ note
1						
2						

5.23. Confirmation of suitability of transport equipment

Evidence of the suitability of the transport containers for both internal and external transport shall be provided. This proof can be provided by means of a description including a picture or sketch of the packaging.

5.24. PPF status of supply chain

Any evidence of approved sampling by subcontractors must be submitted.

5.25. Approval of coating systems

For coatings, specifications are defined by the R&D department of PDSYS. In the case of sampling, proof of compliance with the respective specification must be provided.
In the case of standard coatings, suitable proof must be provided or coordinated with PDSYS.

5.26. Master sample

In case of systematic deviations from the specifications released by the PDSYS, it is recommended to define a reference sample with the PDSYS. This definition must be actively initiated by the supplier.

5.27. Qualified laboratory documentation

Drawing parts may only be handed over to third parties in consultation with PDSYS. In the case of permission, proof of accreditation of the third party must be submitted to PDSYS. A consultation with PDSYS regarding the non-disclosure agreement is mandatory in such cases.

6. Attachments

The annexes listed are examples. Templates can be obtained directly from the VDA or AIAG websites.

- Pre sampling meeting
- Submission_Covering Page
- Submission _Index
- Submission _Dimensional Data Sheet
- Submission _Process flow diagram
- Submission _Control plan
- Submission _Parts history